

# Work Order ID 73499

Wednesday, October 05, 2011 11:20:25 AM

Page 1

Item ID: D2519

Accept

Revision ID:

Item Name: Clamp

Start Date: 9/1/2011 Start Qty: 50.00

Required Date: 9/8/2011 Req'd Qty: 50.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2519

Rev D

101

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

cut per drwg D2519 rev.D

BI-10-28

102

0.00



QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

BI-10-28

103

0.00



QC

QC8- Inspect parts - second check

Memo

0.00

Quality Control

M 11 10 28 51

W/O: 13499		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2579 PAR #: N/A Fault Category: Sim Job NCR: Yes No DQA: u Date: 11/12/05  
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: u Date: 11/12/05

NCR: 11-1040		WORK ORDER NON-CONFORMANCE (NCR) 9.43						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11-11-29	103	1 piece found with small Pinna hole in it. Not suppose to be there. Machine error.	<u>u</u> 11.11.30 QSI 042	Scrap & Destroy	<u>u</u> 11/11/30	<u>u</u> 11-11-28	<u>u</u> 11-11-30 QSI 042	<u>u</u> 11-11-28

NOTE: Date & initial all entries

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Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130



Small Fab

Small Fab

Memo

1-Deburr any rough edges  
2-Bend as per Dwg D2519

0.00

0.00

SB 11/11/30

11-10-28

51

52

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

11-11-30 51

150



Packaging

Packaging

Identify as per dwg & Stock Location: 459

Memo

0.00

0.00

11/11/30 counts

52

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 73499**

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Wednesday, October 05, 2011 11:20:25 AM

Item ID: D2519

Accept



Setup Start



Revision ID:

Stop



Item Name: Clamp

Start Date: 9/1/2011 Start Qty: 50.00



Cust Item ID:

Required Date: 9/8/2011 Req'd Qty: 50.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

n/rz/1 28

CZu/1/29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, October 05, 2011 11:20:22 AM

Page 1

Work Order ID: 73499



Parent Item: D2519

Parent Item Name: Clamp

Start Date: 9/1/2011

Required Date: 9/8/2011

Start Qty: 50.00

Required Qty: 50.00

Comments: IPP: B1100.03.1611 Re-format, laser cutting11 ECI11 IPP REV:C 11.10.05  
MADE IN HOUSE DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S16GA

Purchased

No

sf

94.2000

3.5

3.7



B11710-08

304/316 Sheet .063

Location

Loc Qty

Loc Code

MAT020

94.2

118964

94.2

118964

32

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries



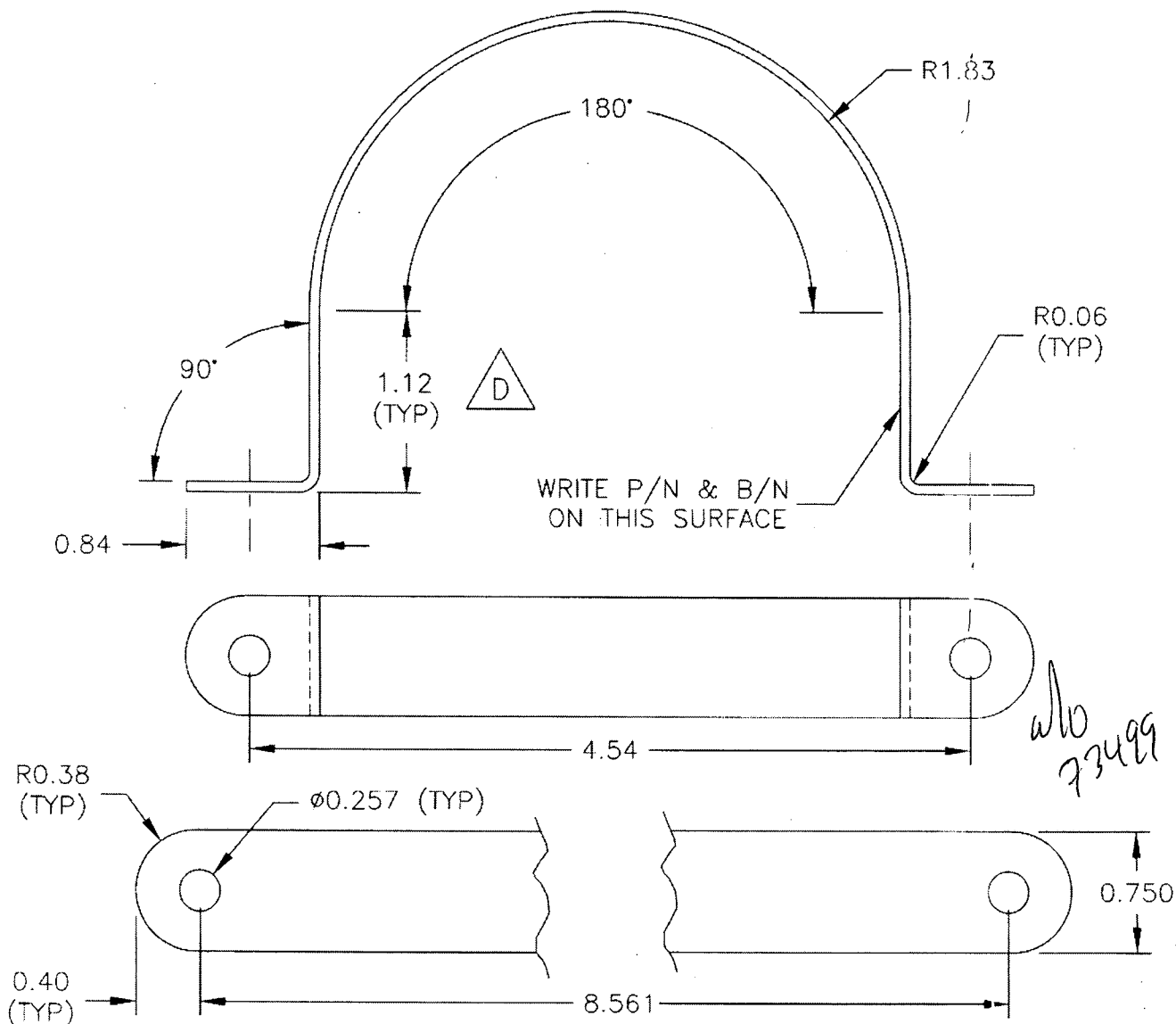






DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2519	REV. 0 SHEET 1 OF 1
DATE 04.11.08		TITLE CLAMP	SCALE 1:1
A	95.11.28	NEW ISSUE	
B	97.03.24	ADD MATERIAL SPECIFICATION	
C	00.02.29	REDRAWN; ADDED FLAT PATTERN	
D	04.11.08	1.12 WAS 0.93	

RELEASED  
04.11.26



### D2519 FLAT PATTERN

#### NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.063 (16 GAUGE) THICK, (REF. DART SPEC. M304S16GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSION ARE IN INCHES
- 4) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT INK MARKER ON SURFACE SHOWN

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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